

Work Order ID 50783 -1

July 22, 2009 12:46:57 PM

Page 1

Item ID: D3891-041

Accept

Setup Start

Revision ID: A

Stop

Item Name: Panel, Fwd LH

Start Date: 07/22/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 07/24/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 09-07-23

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3891

A

4

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3891-1

Dwg Rev: *2*

Prog Rev: *2*

HB 9-7-23

2-Deburr if necessary

④

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-7-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50783

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Setup Start



Stop



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Required Date: 07/24/2009 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Memo

0.00



Small Fab

Debur if necessary

0.00

Small Fab

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

⇒ 509/07/23

(24)

4

—

m-h 09/07/23

(4X)

W/O:		WORK ORDER CHANGES						
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Stop



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Cust Item ID:

Required Date: 07/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond gasket to smooth side of panel as per dwg
A/R 3M 1300 adhesive Batch: M111428

m-k 09/07/24



160

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

=> Sort box



170

0.00



Packaging

Packaging

Identify as per dwg & Stock Location: SHIP

Memo

0.00

09/17/24

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item Name: Panel, Fwd LH

Start Date: 07/22/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 07/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09607127 JF

W 9-07-24

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Page 1

July 22, 2009 12:46:56 PM

Work Order ID: 50783



Parent Item: D3891-041RevA



Parent Item Name: Panel, Fwd LH

Start Date: 07/22/2009

Required Date: 07/24/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	709.8406	19.6042			
GE PLASTICS LEXAN SHEET												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	709.8406316	
103106	7.8	
105330	54	
109455	0.03	
111710	648.010632	

D3891-3RevA

Manufactured No



Gasket

140 Each 0.0000 4.0000



11710 18 9-7-23

W/O:		WORK ORDER CHANGES						
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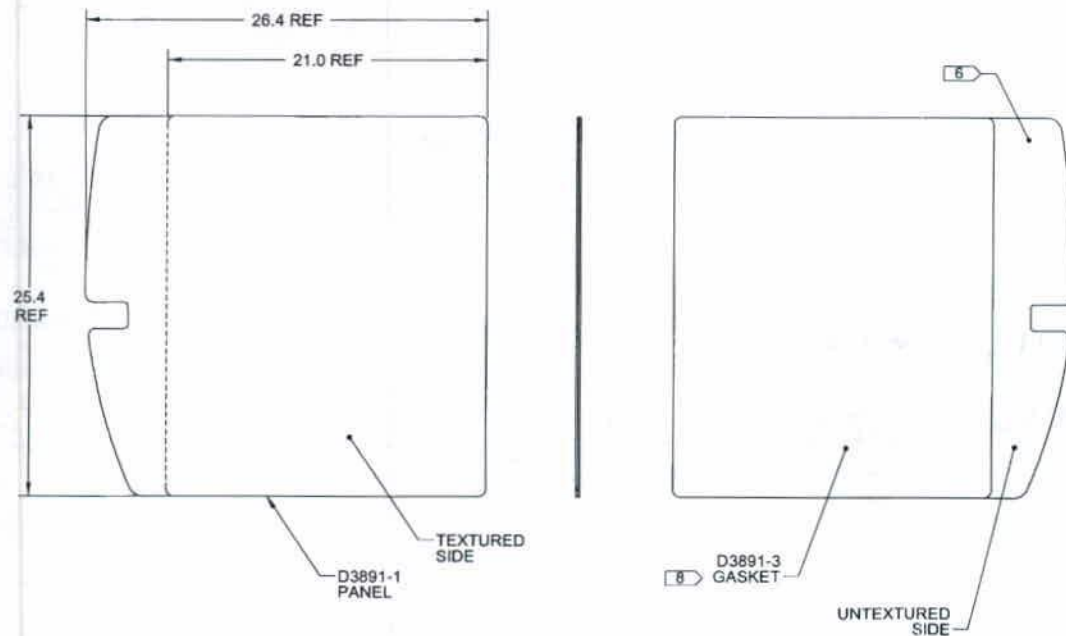
QA: N/C Closed: _____ Date: _____

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PARTS LIST

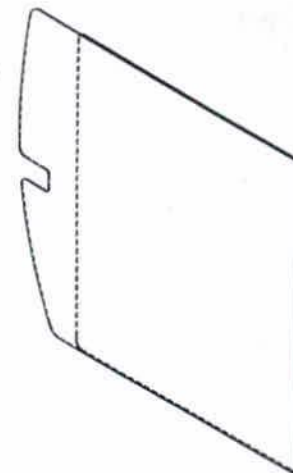
ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE



D3891-041 PANEL, FWD LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 3.67 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.



50783

RELEASED
C9/06/16

REV.	NEW ISSUE	DESCRIPTION	CP	09.05.01
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.05.01			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3891
TITLE PANEL, FWD
REV. A
SHEET 1 OF 6
SCALE NTS

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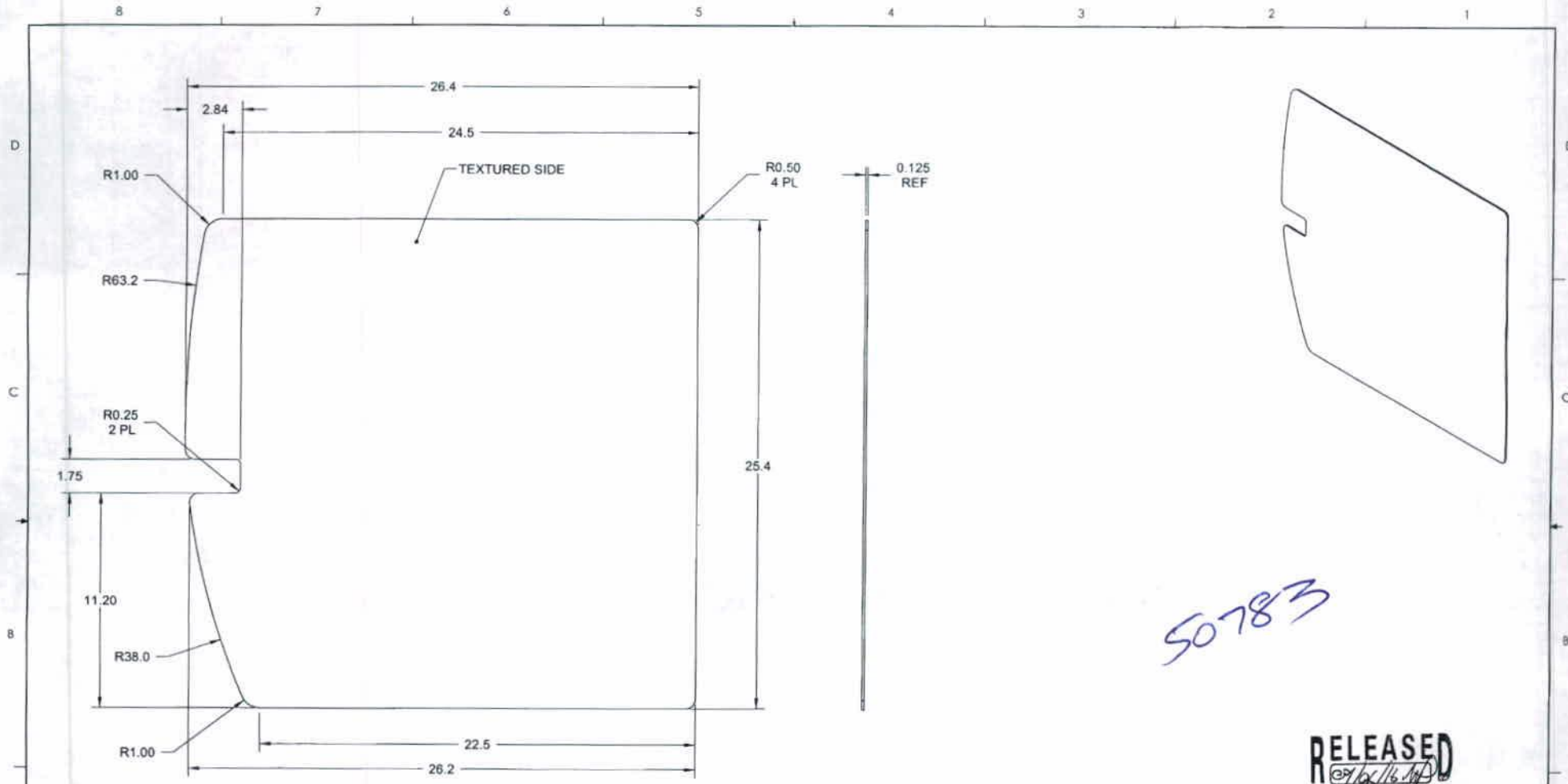
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50783

RELEASED
07/16/14

D3891-1 PANEL

NOTES:

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.46 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3891	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		PANEL, FWD	NTS
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